

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015610**Date Inspected:** 13-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 9BE-9CE

ABF Request No: 07132010-1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the edge panel splice weld between OBG segment 9BE and 9CE (Bike path side). Inspection was carried out on repair areas. The weld designations are as follows.

OBE9- 010 (OBG 9BE-9CE- E.P, BK side)

OBG SEGMENT 9CE

ABF Report No: UT-9E-062

WELDING INSPECTION REPORT

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This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and edge panel (Bike path side) of OBG segment 9CE. The weld designations are as follows.

CA064-005 (OBG 9CE-S.P to E.P, BK side @ 9BE)

OBG SEGMENT 9BE

ABF Report No: UT-9E-061

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the weld between side panel and edge panel (Bike path side) of OBG segment 9BE. The weld designations are as follows.

CA060-001 (OBG 9BE-S.P to E.P, BK side @ 9CE)

OBG SEGMENT 9BE-9CE

ABF Report No: UT-9E-060

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern “D” UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a data sheet that Caltrans QA generates after performing a joint inspection. The members are identified as the side panel splice weld between OBG segment 9BE and 9CE (Bike path side). The weld designations are as follows.

OBW9B-009, 010 (OBG 9BE-9CE, S.P, BK side)

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 9CE-9DE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067765 performing Shielded Metal Arc Welding process for weld 004 located on PCMK OBE9C. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067942 performing Shielded Metal Arc Welding process for weld 005 located on PCMK OBE9C. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 015 located on PCMK DP698-001. ZPMC QC Mr. Wang Li Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4114-1.

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 9BE-9CE

ABF Request No: 07132010-1

WELDING INSPECTION REPORT

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This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on the edge panel splice weld between OBG segments 9CE and 9BE (Bike path side). Inspection was carried out on repair areas. Weld identification number were.

OBE9- 010 (OBG 9BE-9CE- E.P, BK side)

No relevant indications were observed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
